



Dart Aerospace Ltd.
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RBW6505G00331-3T

Job Sheet 198289



Part No: RBW6505G00331-3T

Job Qty: 1 pcs

Part Name: AW139 Common Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17771

Note: DWG RBW6505G00331-3T Rev. D IPP Rev. A 18.09.25 New issue DP Verify DD/IPP Rev. B 19.03.04 drawing revision DP Verify DD/IPP Rev. C 19.06.25 Drawing Revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	9/20/19		0.00	0.17	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		GP 19-09-27
110	QC 5	1 pcs	9/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	9/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1650-E 3-Deburr holes and remove chips from case, 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6505G00331-3T-4 to RBW6505G00331-3T-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1650-E	Case	1 Ea (1 ea)	100-Small Fab - 1	50208415
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 1	5621040
RBW6500X01611-W142E-3T	Oil Seal Housing Removal Pulle.	1 pcs (1 ea)	100-Small Fab - 1	5203394
RBW6500X01611-W142F-3T	Oil Seal Removal Press Tool	1 pcs (1 ea)	100-Small Fab - 1	214603
RBW6505G00331-3T-2	Bottom Foam use in case APP-1650-E	1 Ea (1 ea)	100-Small Fab - 1	208414
RBW6505G00331-3T-3	Top Foam use in case APP-1650-E	1 Ea (1 ea)	100-Small Fab - 1	208413
RBW6505G00331-3T-4	Inside Box Placard	1 pcs (1 ea)	100-Small Fab - 1	521763
RBW6521A00138-W142AH-3T	Nut Torque Tool	1 pcs (1 ea)	100-Small Fab - 1	521763
RBW6521A00138-W142N-3T	Oil Seal Assembly Support Tool	1 pcs (1 ea)	100-Small Fab - 1	210718
RBW6521A00138-W142P-3T	Oil Seal Assembly Press Tool	1 pcs (1 ea)	100-Small Fab - 1	208682
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 1	5206761
RBW6521A00138-W142AH-002-3T	Nut Torque Tool	1 pcs (1 ea)	100-Small Fab - 1	5165817

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	4	161	0
	APP-1650-E	1	6	0
	RB41011	1	267	0
	RBW6500X01611-W142E-3T	1	0	0
	RBW6500X01611-W142F-3T	1	0	0
	RBW6505G00331-3T-2	1	1	0
	RBW6505G00331-3T-3	1	1	0
	RBW6505G00331-3T-4	1	0	0
	RBW6521A00138-W142AH-002-3T	1	1	0
	RBW6521A00138-W142AH-3T	1	0	0
	RBW6521A00138-W142N-3T	1	0	0
	RBW6521A00138-W142P-3T	1	0	0
Part Specifications				
Specifications could not be found.				

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ITEM #

QTY

PART #

PART TITLE

-1

1

RBW6505G00331-3T-1

PACKAGING ASSEMBLY

-4

1

RBW6505G00331-3T-4

CONTENT PLACARD

5

1

RBW6500X01611-W142E-3T

OIL SEAL REMOVAL PULLER

6

1

RBW6500X01611-W142F-3T

OIL SEAL REMOVAL PRESS TOOL

7

1

RBW6521A00138-W142N-3T

OIL SEAL ASSEMBLY SUPPORT TOOL

8

1

RBW6521A00138-W142P-3T

OIL SEAL ASSEMBLY PRESS TOOL

9

1

RBW6521A00138-W142AH-3T

NUT TORQUE TOOL

10

1

RBW6521A00138-W142AH-002-3T

NUT TORQUE TOOL

11

1

RB41011

DART PLACARD

12

4

McMaster#97524A032 OR EQUIV.

ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

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WORK ORDER

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ML3

19-07-25

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REV. D

19-708

KPT

SEE PREVIOUS REVISIONS FOR MORE INFORMATION

UPDATED DRAWING TEMPLATE

-2 UPDATED FOAM CUTOUT LOCATIONS

-4 UPDATED ENGRAVING ON PLACARD

REV. D

ECN #

BY

DESIGN

DRAWN

CHECKED

MFG. APPR.

APPROVED

DATE

DESCRIPTION

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBW6505G00331-3T

TITLE

COMMON SEAL REPLACEMENT TOOL KIT

DATE

4/30/2019

REV. D

SHEET 1 OF 5

SCALE

NTS

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NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"

X.XXX = +/- 0.005" / +/- 0.1"

X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: ENGRAVE THE TOOL PIN ON THE DART PLACARD WHERE INDICATED

7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS

8) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM

9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					

Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread									
		Other/Details:									